

# Work Order ID 83849

**\*83849\***

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Thursday, April 26, 2012 1:28:56 PM

Item ID: D3389-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Web  
 Start Date: 4/26/2012 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 5/4/2012 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan:                      Date:                      Tooling:                      Date:                      Run Start **\*NR1\***  
 QC:                      Date:                      SPC (Y/N):                      Date:                      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3389	Rev D								
100	Skidtubes	0.00							
<b>*100*</b>									
Skidtubes	Memo	0.00							
Skidtubes	1- Pick D2500-3-100 2- Deburr 3- Locating from deburred end, drill pilot holes using DT8785 as per dwg D3389. Scribe cut line. 4- Cut to finished length 5- Open holes to finished size as per dwg D3389 6- Deburr								
110	QC6- Inspect dimensions to drawing	0.00							
<b>*110*</b>									
QC	Memo	0.00							
Quality Control									

6 *[Signature]* 4/26/12  
 6 *[Signature]* 4/26/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Thursday, April 26, 2012 1:28:56 PM

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 Item Name: Web  
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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*120*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
130	QC7-Inspect Chemical Conversion Coat	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <u>16</u>	0.00							
<b>*140*</b>									
Packaging	Memo	0.00							
Packaging									

*Handwritten:* 12-05-23

*Handwritten:* \* 6 08E 12-05-23

*Handwritten:* 12-05-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**Work Order ID 83849****\*83849\***

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Thursday, April 26, 2012 1:28:56 PM

Item ID: D3389-1      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
Revision ID:      Stop **\*NS2\***  
Item Name: Web  
Start Date: 4/26/2012      Start Qty: 6.00      **\*6\***      Cust Item ID:  
Required Date: 5/4/2012      Req'd Qty: 6.00      **\*6\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									

12/5/30 J  
mcs 12/05/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

Thursday, April 26, 2012 1:29:01 PM

Work Order ID: 83849

\*83849\*

Parent Item: D3389-1

\*D3389-1\*

Parent Item Name: Web

Start Date: 4/26/2012

Required Date: 5/4/2012

Start Qty: 6.00

Required Qty: 6.00

## Comments:

IPP Rev:A05.08.31New issueKJ/JLM

IPP Rev:B 06-02-08 As per Rev C JLM

IPP Rev:C 07-11-13 ECN 1056 Rev D dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2500-3-100

Manufactured

No

100

Each

52.0000

1

\*D2500-3-100\*

\*\*

6

12-05-22

Ext'n - 'I' Beam Web 4"

## Location

## Loc Qty

## Loc Code

LG

52

51257

2

79041

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

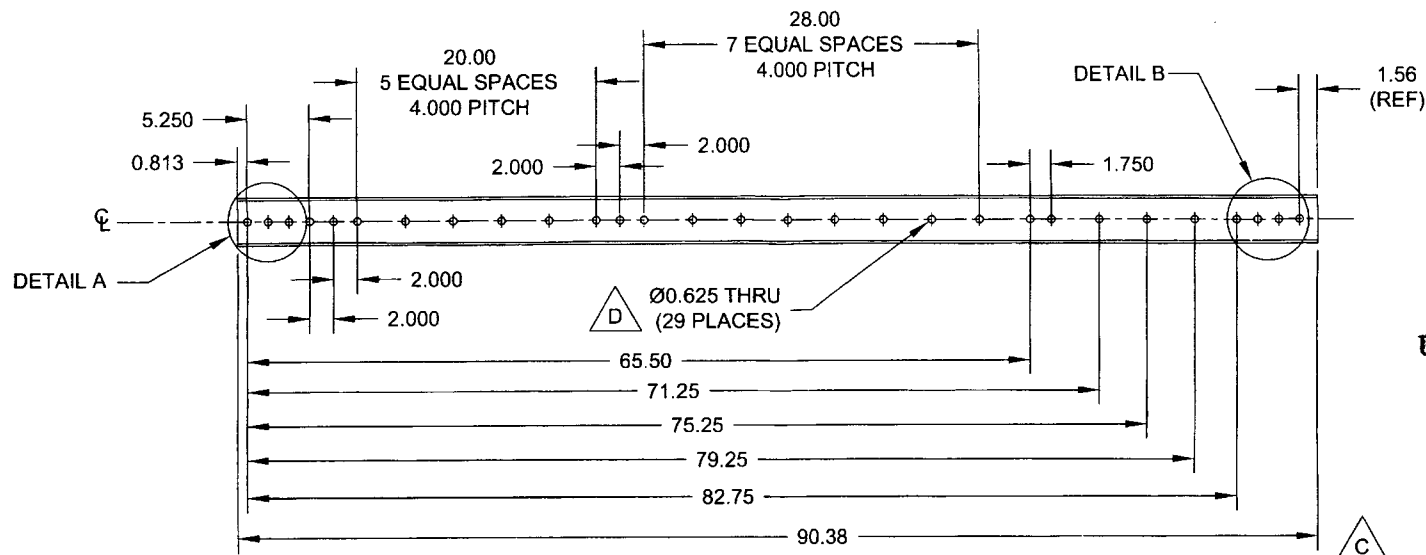
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

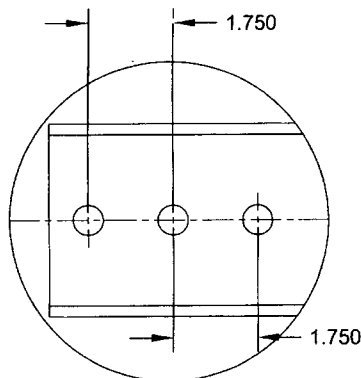
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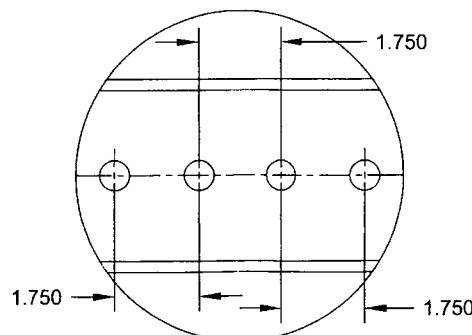




D3389-1 412 WEB



DETAIL A  
SCALE 2:5

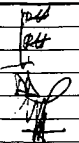


DETAIL B  
SCALE 2:5

NOTES:

- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.6 lbs

RELEASED  
07.11.06 MJD

D	REVISE HOLE DIAMETER FROM Ø0.257 TO Ø0.625, ZONE D4; REFORMAT DRAWING	PH	07.10.09
C	DECREASE OVERALL LENGTH, MODIFY HOLE	PH	06.01.23
B	UPDATE DIMENSIONING	PH	05.06.13
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3389	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.	412 WEB		1:10
DATE	07.10.09	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 83849

PD-0428

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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